

[ line 31, after "9503056-5", please insert --which corresponds to U.S. Serial

a1 No. 08/703,965, herein incorporated by reference,--.

[ Page 2, line 5, after "9504304-8", please insert --which corresponds to U.S. Serial

a2 No. \_\_\_\_\_ filed concurrently herewith (Attorney Docket No. 024444-499),--;

[ line 19, after "9503056-5", please insert --which corresponds to U.S. Serial

a3 No. 08/703,965,--;

[ line 22, after "316-Ti", please insert --,--;

line 24, after "bars", please insert --,--;

line 25, after "9504304-8", please insert --which corresponds to U.S. Serial

a4 No. 09/077,360 filed concurrently herewith (Attorney Docket No. 024444-499),--;

[ line 27, before the paragraph beginning "A turning tool insert", please insert

the following:

--OBJECTS AND SUMMARY OF THE INVENTION

It is an object of this invention to avoid or alleviate the problems of the prior art.

a5 It is further an object of this invention to provide a coated cutting tool particularly useful for wet turning of toughness-demanding stainless steel components.

In one aspect of the invention there is provided a cutting tool insert particularly for turning of steel comprising a cemented carbide body and a coating wherein said cemented carbide body contains WC, 6-15 wt-% Co and 0.2-1.8 wt-% cubic carbides

05  
of Ti, Ta and/or Nb and a highly W-alloyed binder phase with a CW-ratio of 0.78-0.93  
and said coating comprises

Coat  
- a first (innermost) layer of  $\text{TiC}_x\text{N}_y\text{O}_z$  with a thickness of  $< 1.5 \mu\text{m}$ , and with  
equiaxed grains with size  $< 0.5 \mu\text{m}$

- a second layer of  $\text{TiC}_x\text{N}_y\text{O}_z$  with a thickness of  $2-5 \mu\text{m}$  with columnar grains with  
an average diameter of  $< 5 \mu\text{m}$  and

- an outer layer of a smooth, fine-grained ( $0.5-2 \mu\text{m}$ )  $\kappa\text{-Al}_2\text{O}_3$  with a thickness of  
 $0.5-6 \mu\text{m}$ .

In another aspect of the invention, there is provided a method of making an insert  
for turning comprising a cemented carbide body and a coating wherein a WC-Co-based  
cemented carbide body with a highly W-alloyed binder phase with a CW-ratio of 0.78-0.93  
is coated with

- a first (innermost) layer of  $\text{TiC}_x\text{N}_y\text{O}_z$  with  $x+y+z=1$ , with a thickness of  $0.1-1.5 \mu\text{m}$ , with equiaxed grains with size  $< 0.5 \mu\text{m}$  using known CVD-methods

- a second layer of  $\text{TiC}_x\text{N}_y\text{O}_z$  with  $x+y+z=1$ , with a thickness of  $2-8 \mu\text{m}$  with  
columnar grains with a diameter of about  $< 5 \mu\text{m}$  deposited by MTCVD-technique, using  
acetonitrile as the carbon and nitrogen source for forming the layer in a preferred  
temperature range of  $850-900^\circ\text{C}$  and

- a layer of a smooth  $\kappa\text{-Al}_2\text{O}_3$  with a thickness of  $0.5-6 \mu\text{m}$ .

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS OF THE INVENTION--;

line 30, please delete "well balanced" and insert therefor --well-balanced--;

and

lines 33-34, after "with", please insert --,--; after "e.g.", please insert --,--;

and please delete "SiC based" and insert therefor --SiC-based--.

Page 3, line 4, please delete "magnetisation" and insert therefor --magnetization--;

line 9, after "invention", please insert --,--;

line 12, after "invention", please insert --,--; and

line 13, please delete "is provided".

Page 4, line 9, please delete "stabilised" and insert therefor --stabilized--;

lines 15-16, please delete " $\mu$  m" and insert therefor -- $\mu$ m--;

line 23, after "invention", please insert --,--; and

line 30, after "Co", please insert --,--; and after "Co-content", please insert

--,--.

Page 5, line 13, after "in", please insert --,--; and after "e.g.--", please insert --,--;

lines 14-15, after "EP-A-523 021", please insert --which corresponds to

U.S. Patent No. 5,674,564, herein incorporated by reference--; and please delete " $\mu$  m"

and insert therefor -- $\mu$ m--;

lines 21-22, after "wet-blasting", please insert --of--; and please delete "fine grained" and insert therefor --fine-grained--;

line 25, after "9402543-4", please insert --which corresponds to U.S. Serial

No. 08/497,934, herein incorporated by reference--; and

[ after line 26, please insert the following new paragraph:

--The invention is additionally illustrated in connection with the following

a8 Examples which are to be considered as illustrative of the present invention. It should be understood, however, that the invention is not limited to the specific details of the Examples.--.

Page 6, line 3, after "process", please insert --,--;

line 4, after "EP-A-523 021", please insert --which corresponds to U.S.

a9 Patent No. 5,674,564, was used--;

line 7, please delete "SiC containing" and insert therefor --SiC-containing--;

line 19, after "process", please insert --,--;

line 20, after "EP-A-523 021", please insert --which corresponds to U.S.

9/10 Patent No. 5,674,564, was used; and

line 23, please delete "SiC containing" and insert therefor

--SiC-containing--.

Page 10, after the last paragraph ending at line 14, please insert the following new paragraph:

--The principles, preferred embodiments and modes of operation of the present invention have been described in the foregoing specification. The invention which is intended to be protected herein, however, is not to be construed as limited to the particular forms disclosed, since these are to be regarded as illustrative rather than restrictive.

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